

Date: Friday, 09/05/2008 1:47:06 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LH STEP ACTUATOR ASSEMBLY
Job Number :	39167		
Estimate Number :	12758		
P.O. Number :		Part Number :	41232 000 001 001
This Issue :	09/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	41232-000-001 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	35059	Drawing Revision :	A
	Type :	Material :	
	SMALL / MED FAB	Due Date :	30/05/2008
Written By :		Qty:	2
Checked & Approved By :	JLD 08.5.09	Um:	Each
Comment :	Est Rev:A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.5.13



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001

CHG 002

D205-763
So 8/08/23

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

BARBED ELBOW

Batch:

M103727

JS 08/05/15

(X2)

4.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M107321

JS 08/05/15

(X2)

5.0	MS21042L4	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M106051

JS 08/05/15

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 AN423A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M103688

AS 08/05/15

(X2)

7.0 MS3548993 GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GROMMET

Batch:

M106168

AS 08/05/15

(X2)

8.0 AN960JD416L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

M107008

AS 08/05/15

(X2)

9.0 MS24665151 Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cotter Pin

M14526

AS 08/05/15

(X2)

10.0 MS203923C21 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

M104156

AS 08/05/15

(X2)

11.0 R 3400 plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total: 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch:

M104229

comp says NO QTY
New Box & Batch

AS 08/05/15

(X2)

12.0 41232 200 006 001 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

Batch:

30505

AS 08/05/15

(X2)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Spacer (Step Actuator)

Batch:

30503

AS 08/05/15 (X2)

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Reducer Tee Assembly

Batch:

31779

AS 08/05/15 (X2)

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring (Step Actuator)

Batch:

30941

AS 08/05/15 (X2)

16.0

41232 200 001 001

Step Actuator LH Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Step Actuator LH

Batch:

B39174

AS 08/09/23 (X2)

17.0

124K002 4CR 0545

Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Hose ass'y-Step Actuator

BATCH:

M104042

AS 08/05/15 (X2)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/23 (X2)

19.0

PACKAGING.1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location:

PPP Rev:

Rev B

AS 08/09/23 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 39167

Part Number: 41232 000 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/23
JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

A			1	1	17	PS4025E000DF540A	HOSE						
			1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634					
			2	2	15	AN960JD416	WASHER						
			1	1	14	MS21042-L4	NUT						
			1	1	13	AN4-23A	BOLT						
		AR	AR	12		MIL-S-8802	SEALANT						
			1	1	11	MS35489-93	GROMMET						
			2	2	10	AN960JD416L	WASHER						
			1	1	9	MS24665-151	COTTER PIN						
			1	1	8	MS20392-3C21	PIN						
			2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309					
			1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)					
			3	3	5	41232-200-005-001	SPACER						
			1	1	4	41232-200-004-001	REDUCER TEE						
			1	1	3	41232-200-003-001	SPRING						
			1		2	41232-200-001-002	R/H ACTUATOR ASSY						
			1	1		41232-200-001-001	L/H ACTUATOR ASSY						
						-002	R/H INSTALLATION						
						-001	L/H INSTALLATION						
			-002	-001	FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY													
LIST OF MATERIAL													
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UNLESS OTHERWISE SPECIFIED X.S.1 XOL.S.03 XOL.S.010 ANGLES ±.1° FINISH													
DFTSMAN CHECK D. NELSON D. MURPHY 5/20/02 5/20/02 TITLE STEP ACTUATOR INSTALLATION DWG. SIZE C SCALE NONE Dwg. No. 41232-000-001 SHT 1 OF 2 REV. A Era Aviation, Inc.													
41232-1000 NEXT ASSEMBLY													

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 WITHOUT NOTICE
 WORK ORDER
 NO. 391107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

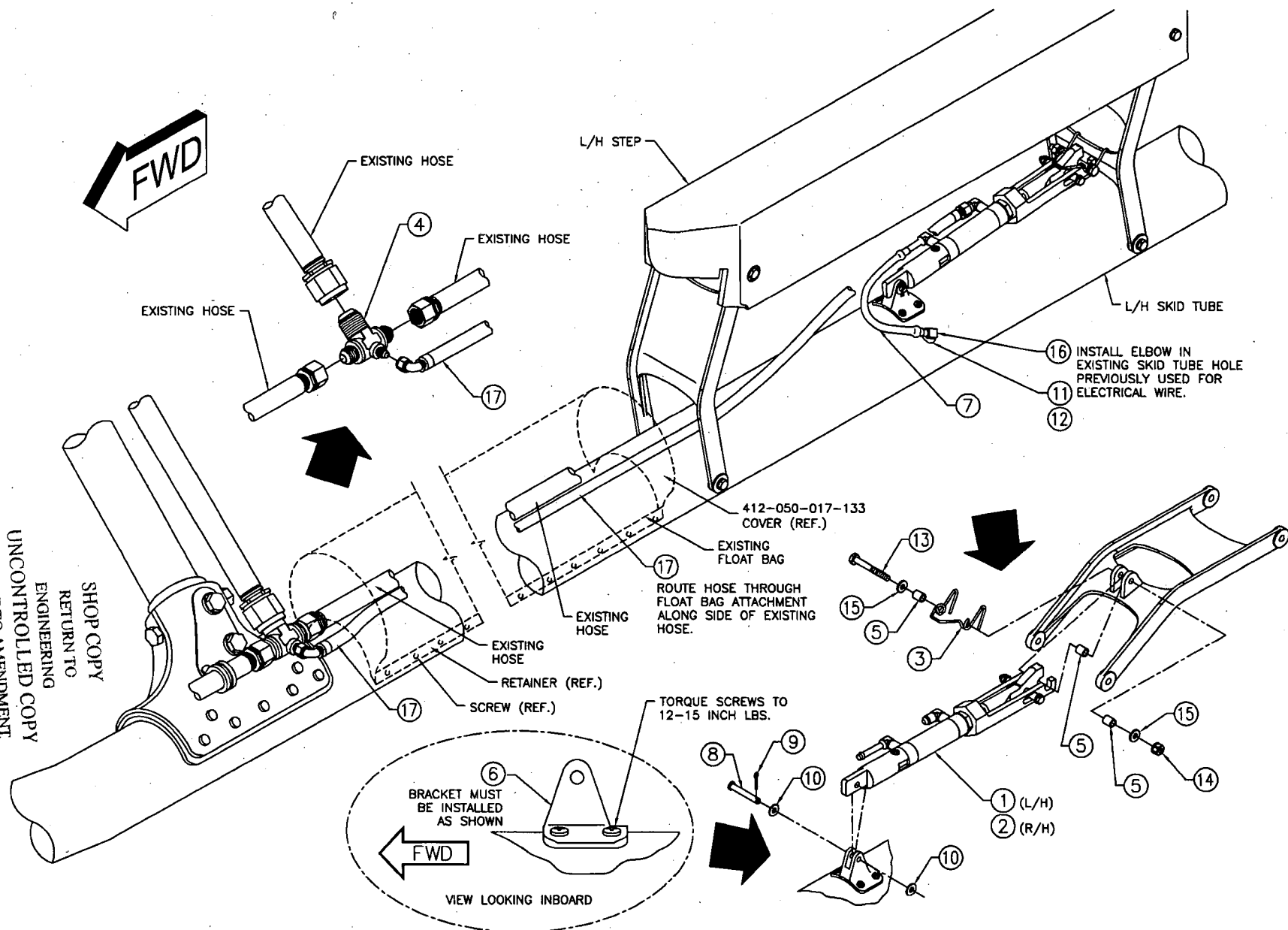
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

NO. 51107
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 -002 R/H INSTALLATION (OPPOSITE)

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Era Aviation, Inc.

TITLE
 STEP ACTUATOR INSTALLATION

REV.
 C

DRG. NO.
 41232-000-001
 SHT 2 OF 2

REV.
 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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